

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028575**Date Inspected:** 10-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing of ESW**ESW T, Face A:**

This QA performed Ultrasonic Testing (UT) of Tower Electroslag Complete Joint Penetration (CJP) shear plate welds designated as "ESW T" on face A. .

This weld was previously tested by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

Testing was performed to verify previous findings of transverse indications. This QA verified location, depth, and indication ratings for assigned indications at each joint.

The following indications were observed as having a transverse orientation. Due to joint configuration and weld cap shape these indications could not be evaluated for length or "X" location.

Y locations are recorded as:

ESW T

Indication #1: Y= 530mm

Sizing – A=82db, B= 53db, C= 8db, D= 21db

Sound Path= 120.7mm, Depth= 40.90mm

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Indication #2: Y= 680mm

Sizing – A=82db, B= 53db, C= 9db, D= 20db

Sound Path= 14.4mm, Depth= 47.75mm

Indication #3: Y= 890mm

Sizing – A=82db, B= 53db, C= 10db, D= 19db

Sound Path= 156.3mm, Depth= 52.97mm

Indication #4: Y= 830mm

Sizing – A=79db, B= 53db, C= 6db, D= 20db

Sound Path= 95.91mm, Depth= 32.48mm

Indication #5: Y= 1480mm

Sizing – A=76db, B= 53db, C=14 db, D= 15db

Sound Path= 200.9mm, Depth= 68.05mm

This QA performed UT of welds designated as ESW T in accordance with the approved supplemental procedure. This testing was performed in tandem with QC technician Andrew Keech. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Due to QA/QC disagreement on indication interpretation, tandem report may not reflect all indications discovered by QA at time of testing.

***Note:**

Quality control personnel have altered the system for recording Y location. The 9m diaphragm will no longer be recorded as a default "Y=6000". All measurements will be taken from the base plate representing 0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation was relevant to testing performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer